

Work Order ID 115515

April-02-14 11:16:18 AM

\*115515\*

Page 1

Item ID: D3391-025

Accept

\*N900040100\*

Setup

Start

\*NS1\*

Revision ID:

Item Name: Aft Tube Assembly

Stop

\*NS2\*

Start Date: 4/02/14 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: MLS

Date: 14-04-02 Tooling:

Date:

Run

Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr	
----------	--------------	--

D3391	I	
-------	---	--

100 0.00

\*100\* MORI SEIKI CNC LATHE LARGE

Mori Seiki

Mori Seiki CNC Lathe Large

Memo 0.00

Turn as per Folio FA599 Rev: A4 & Dwg D3391 Rev: H

\*\*\*\*REMOVE STEADY REST AND MACHINING MARKS\*\*\*\*

110 0.00

\*110\* QC

Quality Control

Memo 0.00

14-04-04

KC

112 0.00

\*112\* QC

Quality Control

Memo 0.00

DAS

27

9-89

4/4/14

1 4

14-04-04

Work Order ID 115515

April-02-14 11:16:19 AM

\*115515\*

Page 2

Item ID: D3391-025

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Aft Tube Assembly

Stop

\*NS2\*

Start Date: 4/02/14 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

120

DAS

\*120\*

HAAS CNC VERTICAL MACHINING #1

0.00

14

HAAS 1

9-89

HAAS CNC vertical machine #1

Memo

0.00

ark 14/04/28

1

0

130

DAS

\*130\*

QC2- Inspect parts off machine FAI/FAIB

0.00

14

QC

9-89

Quality Control

Memo

0.00

ark 14/04/28

1

0

140

DAS

\*140\*

QC8- Inspect parts - second check

0.00

44

QC

9-89

Quality Control

Memo

0.00

\*\*\*INSPECT INSIDE BORE\*\*\*

1

0

14/04/28



Work Order ID 115515

April-02-14 11:16:19 AM

\*115515\*

Page 3

Item ID: D3391-025

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Aft Tube Assembly

Stop

\*NS2\*

Start Date: 4/02/14

Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 4/16/14

Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

\*NR1\*

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

\*NR2\*

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

150

\*150\*

Skidtubes

Skidtubes

Skidtubes

0.00

DC 14/04/29

Memo

0.00

1-Drill ( PILOT HOLE) aft cap holes per Dwg D3391 using DT8803

160

\*160\*

CNC Bend 1

CNC Delta 100 Bender

BENDING MACHINE - SKIDTUBES

0.00

DC 14/04/29

Memo

0.00

Form as per Dwg D3391 Using Bend Prog 3391025

170

\*170\*

QC

Quality Control

QCS- Inspect part completeness to step on W/O

0.00

DAS  
03  
9-69

Memo

0.00

DP H-4.25

DP 14-4-29

Work Order ID 115515

April-02-14 11:16:19 AM

\*115515\*

Page 4

Item ID: D3391-025

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Aft Tube Assembly

Stop

\*NS2\*

Start Date: 4/02/14 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

\*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop

\*NR2\*

Sequence ID/  
Work Center ID

180

\*180\*

Skidtubes

Operation  
Description

Skidtubes

Set Up/  
Run Hours

0.00

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Skidtubes

Memo

0.00

1-Open Aft cap pilot hole to .208" as per Dwg D3391

2-Drill float bag holes using DT8809 as per Dwg D3391(Holes marked "A" Only.

3-Drill wearplate holes as per Dwg D3391 using DT8878(Mid Tube) & DT8217 Wearplate Jig .

\*\*\*\*\*Do Not Open To Finished Size\*\*\*\*\*

4-Drill Wearshoe holes as per DWG D3391 using DT8939 locating from 2 previously drilled aft wearplate holes.

5-Open wearplate holes to 0.297" and c'bore as per dwg D3391

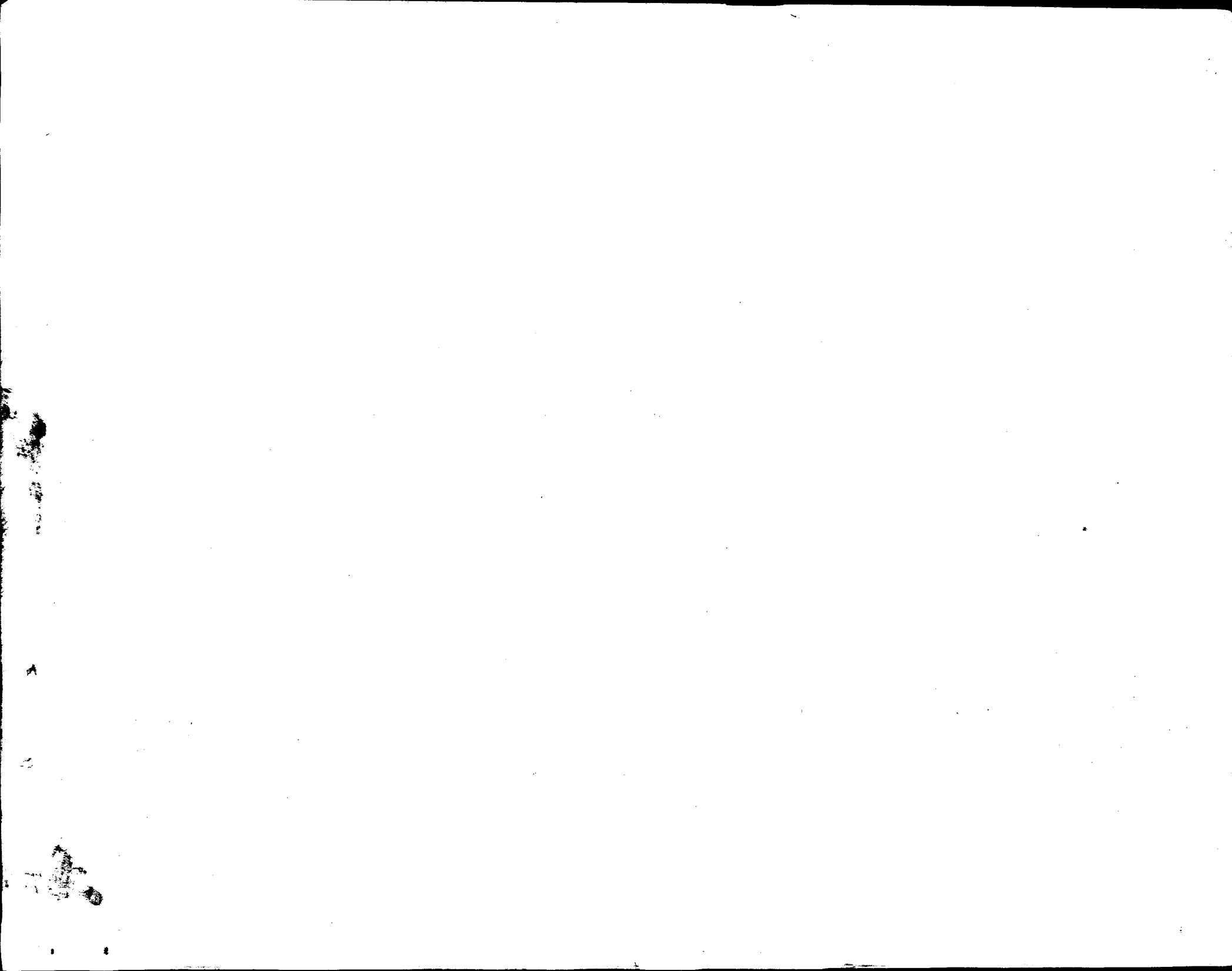
6-Open up all float bag holes to 0.328" and c'sink as per Dwg D3391.

7-Deburr

8- Scribe batch # on fwd end

DC 14/04/2014





**Work Order ID 115515**

April-02-14 11:16:19 AM

**\*115515\***

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Item ID:	D3391-025	Accept	<b>*N900040100*</b>	Setup	Start	<b>*NS1*</b>	
Revision ID:							
Item Name:	Aft Tube Assembly					<b>*NS2*</b>	
Start Date:	4/02/14	Start Qty:	1.00	<b>*1*</b>	Cust Item ID:		
Required Date:	4/16/14	Req'd Qty:	1.00	<b>*1*</b>	Customer:		
Reference:							
Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
	QC:	Date:	SPC (Y/N):	Date:	Stop		<b>*NR2*</b>

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
220	Skidtubes	0.00							
<b>*220*</b>	Skidtubes	0.00							
Skidtubes	Memo	0.00							
	1- Instal spacers as per dwg D3391 A/R Magnabond 6398 Batch: <i>127227 - 02 14/05/05</i> exp. date: <i>19/05/05</i> cure time 12hrs as per QSI0015								
	2- Grind crossbolts flush								
	3- Back drill using #9 drill								
	4- Touchup Magnabond								
	5- Deburr								
230	QC5- Inspect part completeness to step on W/O	0.00							
<b>*230*</b>	QC	0.00							
Quality Control	Memo	0.00							
	<i>JH</i>	<i>14/5/17</i>							

**Work Order ID 115515**

April-02-14 11:16:19 AM

**\*115515\***

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Item ID: D3391-025

Accept

**\*N900040100\***

Setup Start

**\*NS1\***

Revision ID:

Item Name: Aft Tube Assembly

Stop

**\*NS2\***

Start Date: 4/02/14 Start Qty: 1.00

**\*1\***

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

**\*1\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start

**\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

235

Pressure Wash per QSI005 4.3

0.00

**\*235\***

HandFinish

Memo

0.00

Hand Finishing

AND REALODINE AS PER PAR09-043

i 76/47-16

240

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

**\*240\***

Powdercoat

Powder Coating

Memo

0.00

START TIME: 2:40.0  
OVEN TEMPERATURE: 320  
FINISH TIME: 3:10.

1/6/14-9-18. DAS 34 9-89

250

QC3- Inspect Part Finish

0.00

**\*250\***

QC

Quality Control

Memo

0.00

1/6/14-10-22

9-89  
15  
DAS

**Work Order ID 115515****\*115515\***

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April-02-14 11:16:19 AM

Item ID:	D3391-025	Accept	<b>*N900040100*</b>	Setup	Start	<b>*NS1*</b>
Revision ID:						
Item Name:	Aft Tube Assembly				Stop	<b>*NS2*</b>
Start Date:	4/02/14	Start Qty: 1.00	<b>*1*</b>	Cust Item ID:		
Required Date:	4/16/14	Req'd Qty: 1.00	<b>*1*</b>	Customer:		

**Reference:**

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	<b>*NR1*</b>
						Stop	<b>*NR2*</b>
	QC:	Date:	SPC (Y/N):	Date:			

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
260 <b>*260*</b> HandFinish	HandFinishing	0.00							<i>1x of 11 Model 02</i>
Hand Finishing	<b>Memo</b>	0.00							
	1-Install inserts as per Dwg D3391								
	2-Install Aft Cap as per Dwg D3391								
	A/R Sikaflex-241-291 <u>11129817</u>								
	Sikaflex expiry date: <u>4/14</u>								
	3- INSTALL WEARPLATES AS PER DWG								
270 <b>*270*</b> QC	QC5- Inspect part completeness to step on W/O	0.00							<b>DAS</b> <b>38</b> <b>9-89</b>
Quality Control	<b>Memo</b>	0.00							<i>14-10-4</i>
280 <b>*280*</b> Packaging	Identify as per dwg & Stock Location: <u>W16</u>	0.00	10412-742-043	13115495					<i>1x of 11 Model 03</i>
Packaging	<b>Memo</b>	0.00							

Work Order ID 115515

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\*115515\*

Page 9

Item ID: D3391-025

Accept

\*N900040100\*

Setup Start

\*NS1\*

Revision ID:

Item Name: Aft Tube Assembly

Stop

\*NS2\*

Start Date: 4/02/14 Start Qty: 1.00

\*1\*

Cust Item ID:

Required Date: 4/16/14 Req'd Qty: 1.00

\*1\*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:	Stop		*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
290  *290*	QC21- Final Inspection - Work Order Release	0.00							14/11/14 JG
QC	Memo	0.00							
Quality Control									

APR-11-04

# Picklist Print

Page 1

April-02-14 11:16:22 AM

Work Order ID: 115515

\*115515\*  
\*D3391-025\*

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

Comments:

- IPP Rev B 06-02-07 ECN773 dwg rev. D EC
- IPP Rev:C 06-03-28 Update Manuf. Instructions JLM
- IPP rev D 07.03.20 revF dwg EC
- IPP rev E 07.11.07 rev G dwg ecn 1053p EC verified by: DD
- IPP Rev:F 07-11-13 ECN 1056 DD verified by: EC
- IPP Rev:G 08-09-10 revH as per dwg DD verified by:EC IPP Rev:H  
11.11.14 AS PER REV.I DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4095-047		Manufactured	No			260	Each	18.0000	1	1	**		

\*D4095-047\*

Wearpad Assembly

Location	Loc Qty	Loc Code
FP001	18	
102241	2	
<u>108289</u>	16	

D4095-049

\*D4095-049\*

Wearpad Assembly

Location	Loc Qty	Loc Code
FP001	12	
109670	12	3120495
FP002	1	
102216	1	

D6014-090

\*D6014-090\*

ALUMINUM EXTRUSION

Location	Loc Qty	Loc Code
LG003	69	
79742	17	
<u>86063</u>	52	

LL 11/04/02

V1

LL 11/04/02

X1

LL man L 14/04/02

# Picklist Print

Page 2

April-02-14 11:16:22 AM

Work Order ID: 115515

\*115515\*  
\*D3391-025\*

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

D3670-4-200

Manufactured No

230

Each

300.0000

4

4

\*\*

DC14/08/85

Bushing

\*D3670-4-200\*

Location	Loc Qty	Loc Code
FG	10	
87709	10	
LG001	290	
103880	39	
109108	242	
96240	9	

D2646

Manufactured No

270

Each

75.0000

1

1

\*\*

SL 100422

\*D2646\*

Aft Cap

Location	Loc Qty	Loc Code
FG	4	3119656
85848	2	
90495	2	
FP001	71	
103306	14	
107857	1	
110816	18	
113830	38	

# Picklist Print

April-02-14 11:16:22 AM

Page 3

Work Order ID: 115515

**\*115515\***  
**\*D3391-025\***

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

D3672-1

Manufactured No

270

Each

1,420.000

2

2

\*\*

*Al ulocalz*

**\*D3672-1\***

Phenolic Washer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	10	
85222	10	
ST060	1410	
103845	4	
112218	500	
<u>113581</u>	500	<u>X2</u>
93886	224	
99099	182	

ALS4-1032-130

AELS4-1032-130 Purchased

No

260

Each

9,937.000

14

14

\*\*

*Al ulocalz*

**\*AI S4-1032-130\***

Rivnut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	9832	
<u>M128649</u>	9832	<u>X14</u>
ST279	48	
M128211	48	
st510	57	
M126109	57	

# Picklist Print

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April-02-14 11:16:22 AM

Work Order ID: 115515

\*115515\*  
\*D3391-025\*

Parent Item: D3391-025

Parent Item Name: Aft Tube Assembly

Start Date: 4/02/14

Required Date: 4/16/14

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

AELS8-1032-225 Purchased

No

270

Each

1,490.000

8

8

\*\*

W  
Loc 27

\*AI S4-1032-225\*

Rivnut AHS7-1032-225

Location	Loc Qty	Loc Code
----------	---------	----------

FG	30	
----	----	--

M127028	30	
---------	----	--

FP001	1000	
-------	------	--

(M128649)	1000	
-----------	------	--

ST280	426	
-------	-----	--

M127028	10	
---------	----	--

M128179	416	
---------	-----	--

st555	34	
-------	----	--

M127092	34	
---------	----	--

AN3C4A

Purchased

No

270

Each

2,208.000

6

6

\*\*

W  
Loc 22

Bolt \*AN3C4A\*

Location	Loc Qty	Loc Code
----------	---------	----------

FG	20	
----	----	--

122814	20	M129520
--------	----	---------

v6

ST350/513	1000	
-----------	------	--

M128606	1000	
---------	------	--

ST512	3	
-------	---	--

124221	3	
--------	---	--

ST513	1185	
-------	------	--

125388	122	
--------	-----	--

M127410	1	
---------	---	--

M127832	62	
---------	----	--

M128634	1000	
---------	------	--



DQA: \_\_\_\_\_ Date: \_\_\_\_\_



## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order update only 

Work Order: _____	DISPOSITION	AGAINST DEPARTMENT/PROCESS							
Part No. _____	Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Water Jet <input type="checkbox"/>	Engineering <input type="checkbox"/>				
NCR No. _____	Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Quality <input type="checkbox"/>				
	Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Other <input type="checkbox"/>				
	Suspected Unapproved <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Supplier <input type="checkbox"/>					

Root Cause	Date	Step	Qty	Description of work order update or non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Design									
Doc/Data									
Equip/Tooling									
Handling/Pre									
Material									
Operator									
Offset/Setup									
Process									
Supplier									
Training									
Transport									
Unapproved									

### FAULT CATEGORY

Landing Gear	General				
Bending	Bend <input type="checkbox"/>		Folio/Program <input type="checkbox"/>	Outside Dimensions <input type="checkbox"/>	Pressure/Forced <input type="checkbox"/>
Centre Not Concentric	BOM/Route <input type="checkbox"/>		Grain <input type="checkbox"/>	Over/Under tolerance <input type="checkbox"/>	Set-up <input type="checkbox"/>
Cracks	Broken/Damage/Defect <input type="checkbox"/>		Hardware <input type="checkbox"/>	Part Incorrect <input type="checkbox"/>	Temperature/Cure <input type="checkbox"/>
Crimp/Kink/Ripple/Wave	Burrs <input type="checkbox"/>		Inspection Incomplete/Unqualified <input type="checkbox"/>	Part Lost/Missing <input type="checkbox"/>	Weld <input type="checkbox"/>
Cuffs	Contamination <input type="checkbox"/>		Instructions Incomplete/Unclear <input type="checkbox"/>	Part Moved <input type="checkbox"/>	Wrong Stock Pulled <input type="checkbox"/>
Crushing	Countersink <input type="checkbox"/>		Misaligned/off center <input type="checkbox"/>	Positioned Wrong <input type="checkbox"/>	
Heat Treat	Cut Too Short <input type="checkbox"/>		Mislabeled <input type="checkbox"/>	Power Loss/Surge <input type="checkbox"/>	Other <input type="checkbox"/>
Inspection Strip in Tube	Drawing <input type="checkbox"/>		Misread <input type="checkbox"/>		
Marks/Chatter	Drill Holes <input type="checkbox"/>		Off-set <input type="checkbox"/>		
Turning Sequence	Finish <input type="checkbox"/>		Out of Calibration <input type="checkbox"/>		
Wave/Twist in Tube	Fit/Function <input type="checkbox"/>		Out of Sequence <input type="checkbox"/>		

DART AEROSPACE LTD		Work Order:	115515
Description: Float Skidtube (412)		Part Number:	D3391-3
Inspection Dwg: D3391	Rev: I		Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Lathe Section						
14.000	+/-0.010	14.000	/		TAPE	LG-25
3.500	+/-0.010	3.504	/		VERN	CNL-08
Ø3.200	+/-0.010	3.206	/		"	"
Ø3.750	+/-0.010	3.750	/		"	"
30° x 0.060 chamfer	+/-0.010	30° x .060	/		"	"
88.93	+/-0.030	88.93	/		TAPE	LG-25

Measured by: *KC*

Date: 17/04/14

Audited by: *Shp*

Date: 17/04/14

HAAS Section						
1.526	+0.000/-0.030	1.510	/		Vern	ML-06
7.500	+/-0.010	7.500	/		"	
27.750	+/-0.010	27.750	/		<i>H-type</i>	ML-08
31.750	+/-0.010	31.750	/		"	
35.250	+/-0.010	35.250	/		"	
3.300	+/-0.010	3.304	/		Vern	ML-06
0.200	+/-0.010	.200	/		"	
3.520	+/-0.010	3.525	/		"	
0.687	+0.010/-0.000	.690	/		"	
R0.062	+/-0.010	R.062	/		R-1	
Ø0.484	+0.005/-0.001	Ø.485	/		Vern	ML-06

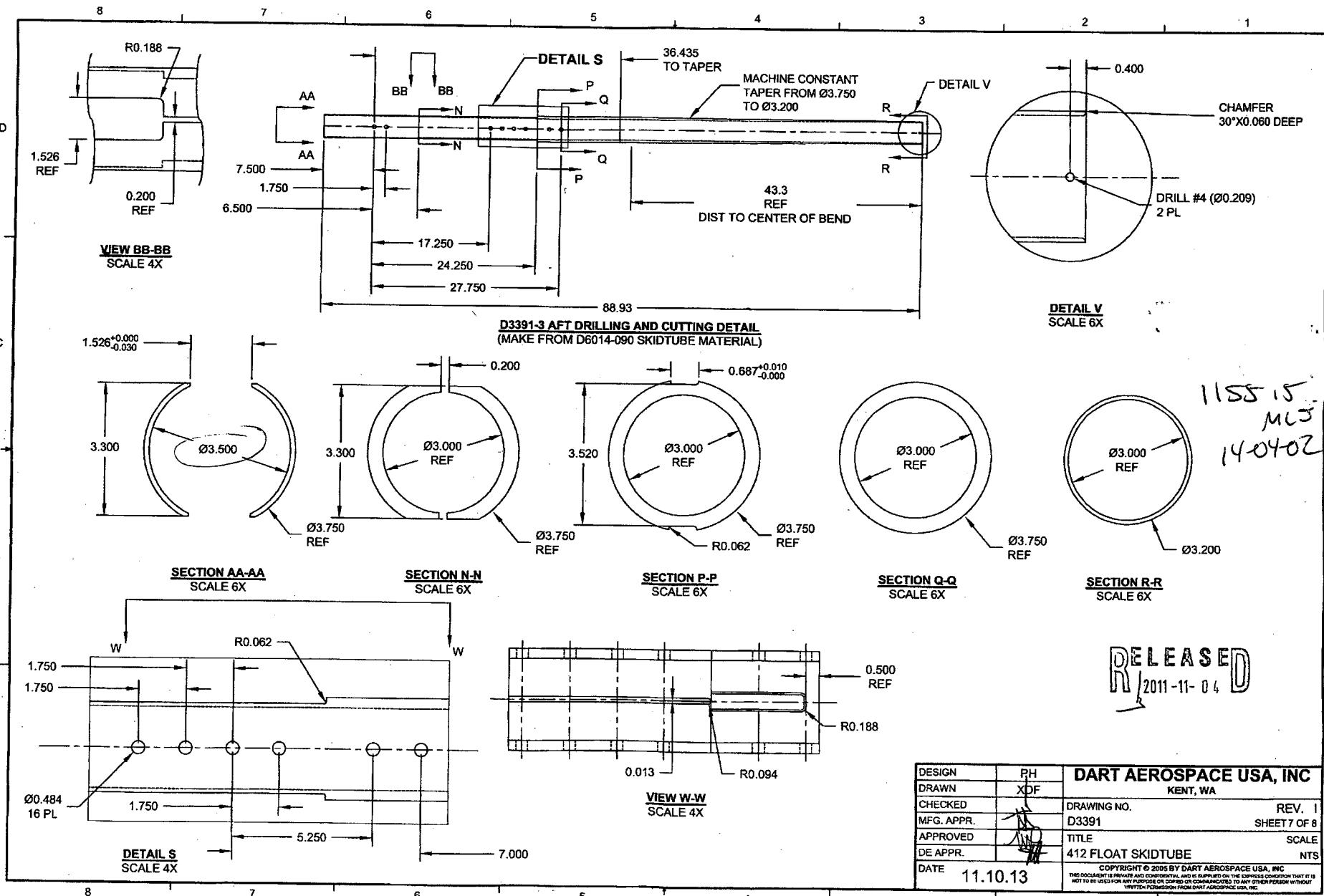
Measured by: *omf*

Date: 14/04/14

Audited by: *F.K.*

Date: 14/04/14

Rev	Date	Change	Revised by	Approved
A	06.04.24	New Issue	P/O D3391-015/-025	KJ/JLM
B	06.06.19	Dwg revision update	KJ/JLM	
C	07.04.20	Ø0.208 dimension removed	KJ/JLM	
D	07.09.06	0.400 dimension removed	KJ/JLM	
E	07.11.23	Dwg Rev. updated	KJ/EC/DD	
F	09.04.27	Dimensions updated per Rev H and NCR09-028	KJ/JLM	
G	09.11.16	Dimension 0.200 removed	KJ	
H	11.06.21	Dimension 44.995 removed	KJ	
I	12.05.15	Dwg Rev updated	KJ	
J	12.05.23	Dimension updated	KJ	
K	12.10.15	88.93 dimension removed	KJ	<i>JK</i>
L	12.11.28	88.93 dimension added	KJ	<i>JK</i>



RELEASED  
2011-11-04

RELEASED  
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC		
DRAWN	XDF	KENT, WA		
CHECKED	<del>11/10/13</del>	DRAWING NO.	REV. I	
MFG. APPR.	<del>11/10/13</del>	D3391	SHEET 7 OF 8	
APPROVED	<del>11/10/13</del>	TITLE	SCALE	
DE APPR.	<del>11/10/13</del>	412 FLOAT SKIDTUBE	NTS	
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